

**MATERIAL EVOLUTION - Status Report**

Nbr 41 of 06.01.1989

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Issued by:
R & D Manufacturing Services Group

* = New trial.
** = Will be dropped (next report).

PROJECT FITIA (Filter Tip Attachment):

Objective: Improve gluing of tippings to filter plug and tobacco rod;
good machinability (envelope, gluing) at speeds up to 8000 cig./min.

STEPS:

- 1 Better know-how regarding tippings and glues. Achieved by discussions with suppliers.
- 2 Set up an Evaluation Procedure for Industrial Trials. Achieved; procedure approved.
- 3 Set up and use a Test Plan for Industrial Trials. Achieved; plan approved by all prod.centers.
- 4 Carry out tests (all brands/levels). Ongoing.

SUMMARY Regarding Benkert Blancophan 390:

- Run well on the machines during small test runs.
- Blancophan 390 is expected to be slightly cheaper than Blancophan 36A.
- **APPROVALS:**
LMBG / Taste approvals: Panels B OK on PMU03, MER13, MAB01/MAH01, MLX12
Panel A OK on PMU03 (includes new perforation L5R/400)
- During the first ind. test (50 bobb.; MER13 at FTR), the machinability was not convincing.
- **PLANNED:**
Finish all Blancophan 390 tests, evaluate results, then discuss with Benkert.

SUMMARY Regarding Malaucène LS 944 BNG:

- Is considered an improvement compared to 944 BNG.
- White and 3-colour tipping type LS 944 BNG cost approx. 7% more than 944 BNG (= approx. 77'000 \$ p.a.).
- **APPROVALS:**
LMBG / Taste : Panels B OK on PMT02, MAG02/MAT01
Machinability: MAG02, with Baumgartner PSP filter +S&H 9500, with TP perforation 4M 0.22.7.5.
- **PLANNED:**
- Finish ind. trial PMT02 (PMG-B), evaluate results and decide on further action (which other cigarettes? which production centers?).

DETAILED TEST RESULTS AND STATUS TO DATE:

STEP	TEST MATERIAL	ENVIRONMENT	AFFIL.	BRAND	START	END	STATUS/RESULT/REMARKS
1 a	Benkert Blancophan 390	FP S&H 9500	PMG-B	MLX12	04/88	08/88	Doubtful B-Panels PMG-M + R&D.
1 b	Repetition 1a	"	510	"	08/88	10/88	OK smoke/Panel B PMG-M + R&D.
2	15 bob. with/without Schl.h."	"	510	"	10/88	11/88	OK machinab.8000/OK.3 B-Panels
	PLANNED:						
	- Accelerate receipt of the 50 bobbins ordered.						
3	- Ind. trial, without Schleifheizung,	550	"	"	01/89	
	at 8000, acc.to FITIA procedure. (Benkert might want to be present during test run.):						
1 a	Benkert Blancophan 390	FP 24-93	FTR	MER13	05/88	08/88	OK incoming/smoke/B-Panel R&D.
1 b1	Runs at 7000 + 8000 cig.;	"	8026	"	"	"	"
	with/without Schleifheiz. "	"	"	"	09/88	10/88	NOT OK machinab. (Dext.24-93?)
1 b2	8000 cig. with/without Sch.PPW 140	"	"	"	09/88	10/88	OK machinab.(small qty avail.)
3	50 bob.; FITIA procedure	FP S&H 9500	8062	"	11/88	01/89	OK incom./machinability?
	PLANNED:						
	- Collect all results and issue report.						

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1	<u>Benkert Blancophan 390</u>	FP S&H 8250+)	PMG-M	<u>PMU03</u>	05/88	09/88	OK smoke/incoming/Panels B + A. LSR/400perf.) 757
	<u>PLANNED:</u>						
3	100 bob. indtrial; FITIA procedure	805	"	"	01/89	Ventilation + machinability?
	3 bob. nests to T.Bel for PPM 300 tests.						
1 a:	Blancophan 36A; 3/50	PSP Bollaré	FTR	<u>MAB01</u>	07/88	07/88) Test with diff. filters;
		+S&H150/9500	8041	"	08/88	09/88) No incoming/OK smoke/Panel B.
1 b	1 bob. <u>Blanco. 390</u> ; 3/50	PSP S&H 9500	"	"	10/88	10/88	Low ventilation
2	15 bob. "	"	"	"	11/88	12/88	OK so-far
3	120 bob. "	3/60 PSP 9500	8100	"	01/89	Machinability? ventilation?
	<u>PLANNED:</u>						
	Indtrial, FITIA procedure, on 18.01.1989.						
1 a1	<u>Malauçène LS 944 BNC</u>	PSP+Bollaré	FTR	<u>MAC02</u>	07/88	08/88) FP Dexter eliminated on PSP;
1 a2	"	PSP+diff. FPs	8005	"	07/88	08/88) TP perforation to be adapted
1 b	TP LS944; perf. 4M0.15.4.5	PSP S&H 9500	8028	"	09/88	09/88	OK filter S&H 9500; low vent.
1 c	" " " 4M0.20.7.5	" " "	8046	"	09/88	09/88	Increased ventilation
-	" " " 4M0.22.7.5	" " "	FTR	"	10/88	10/88	Provisionally adopted constr.
3	" " " "	" " "	"	"	11/88	11/88	OK indtrial; LS/perfo/filter
**	<u>APPROVED</u> ; final report MID 09.12.1988; product specs modified. (perf. 4M0.26.7.5 not needed).						
1	<u>Malauçène LS 944 BNC</u>	S&H 9500	PMG-B	<u>PMT02</u>	06/88	07/88	OK smoke/3 B-Panels.
2	15 bob.; Protos/Max 80	"	496	"	07/88	08/88	OK with/without Schleifheiz.; 7100 cig. only (loose ends).
3	50 bob.; FITIA Procedure	"	544	"	10/88	01/89	
	<u>PLANNED:</u>						
	Test run terminated; report expected WEEK 03/89.						
1	PSP filter 34.9142:	Cork limit	FTR	<u>BRE01</u>	01/89	DEVEL.	(Project NASHVILLE)
	From 400K to S&H 9500	944 BNC		<u>FLI02</u>	01/89	Ventilation? Taste?
	+ porous semi						
	<u>PLANNED:</u>						
	5 cartons of filters available for trials BRE01 (Product Development) and FLI02 (Manuf.Services)						

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